

Work Order ID 112682

February-04-14 3:47:16 PM

112682

Page 1

Item ID: D3898-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Protector (206L)

Start Date: 2/04/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/06/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3898	Rev A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2 3/14/02/05

105

0.00

105

HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

22 14/02/06

Temp: **245 deg. F**

Time IN: **5:00 PM**

Time OUT: **6:00 AM**

14/02/06

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Item ID: D3898-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector (206L)
Start Date: 2/04/14 Start Qty: 2.00 *?
Required Date: 2/06/14 Req'd Qty: 2.00 *?
Cust Item ID:
Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110						2			B14/02/05
Thermoform	Memo	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501 Dwg Rev: <u>A</u> Folio Rev: <u>2</u> Visually inspect for proper formation and texture								
140		0.00							
140						2			B14/02/10
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
150									B14/02/10
QC	Memo	0.00							
Quality Control	Complete FAI document								

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Item ID: D3898-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector (206L)
 Start Date: 2/04/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/06/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				2			
160		0.00							
QC	Memo								
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00				2x	DAS 28 9-89	14-02-10	
170		0.00							
Packaging	Memo								
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00				ML5		14-02-10	
180		0.00							
QC	Memo								
Quality Control									

(H) 14-02-10

Picklist Print

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Work Order ID: 112682

Parent Item: D3898-1

Parent Item Name: Floor Protector (206L)

Start Date: 2/04/14

Required Date: 2/06/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev.A New Issue 09/02/06 DL
10/04/21 DL

IPP RevB Add Step 105 Dry Material

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	3,391.7880	10.6	23			

Location

therm

Loc Qty

3391.788

Loc Code

113127

8

m126994

3383.788

23

8/14

14/07/10

DART AEROSPACE LTD		Work Order: 112682
Description: Floor Protector		Part Number: D3898-1
Inspection Dwg: D3898	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

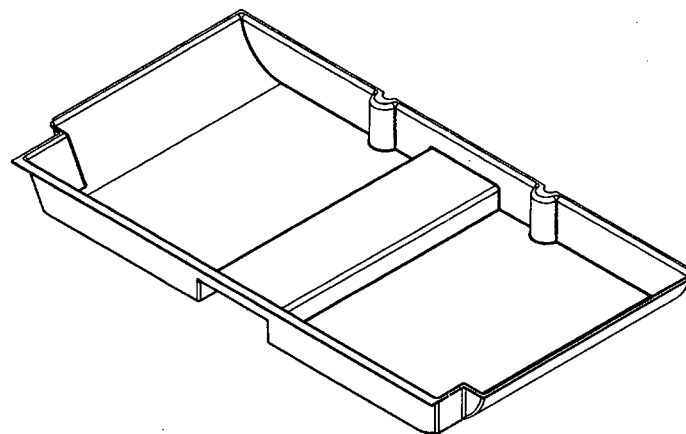
Measured by: <i>BB</i>	Date: 14/02/05
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	.56	✓			
1.00	Min	1.06	✓			
5.6	+0.2/-0.0	5.625	✓			
0.080	Min	.082	✓			
0.050	Min	.057	✓			

Measured by: <i>BB</i>	Date: 14/02/07
Audited by: 27	Date: 14-2-07
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>BB</i>



D3898-1 FLOOR PROTECTOR (206L)

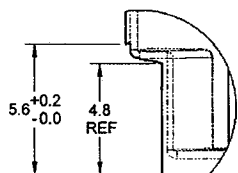
*PH
12682*

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09/02/27

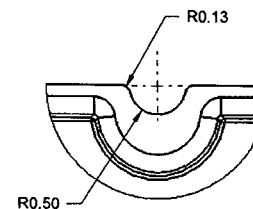
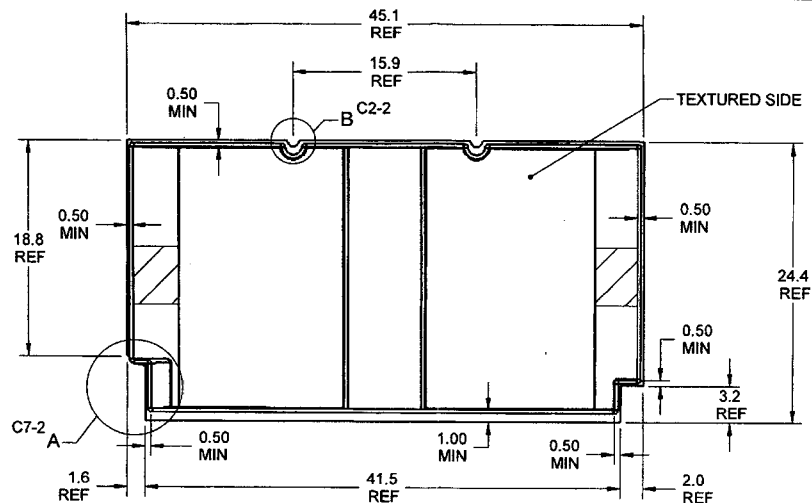
NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

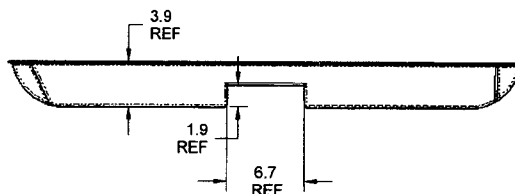
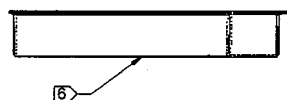
A	NEW ISSUE	PH	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3898	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	FLOOR PROTECTOR (206L)	NTS
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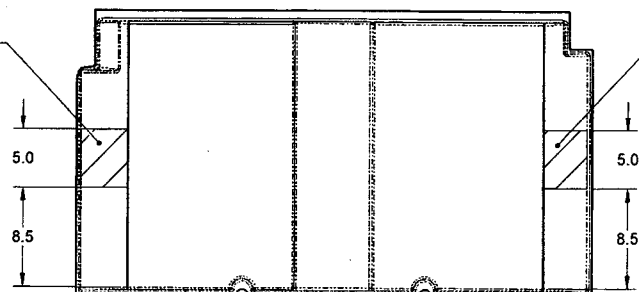
DETAIL A
SCALE 2X



DETAIL B
SCALE 5X
2 PL



MIN THICKNESS
0.080
(SHADED REGION)



MIN THICKNESS
0.080
(SHADED REGION)

D3898-1 FLOOR PROTECTOR (206L)

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09/02/27

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DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	SP	D3898	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR (206L)	NTS
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